



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4634-143
Job Sheet 167077



Part No: D4634-143

Job Qty: 1 ea

Part Name: Middle, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start up container	D.M.L 17-12-12
100	HandThermo	1 pcs		11/9/17	0.00	1.65	HandFinish4	D.M.L 17-12-12
110	Small Fab	1 pcs		11/10/17	0.00	1.47	Small Fab	D.M.L 17-12-12
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	D 17-12-13
130	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	D.M.L 17-12-14
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21	DAS 21

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4634-143 Bond foam core to inside of panel 3M Scotch Weld 1300 8-89 DEC 14 2017
Batch: 138016 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # 138649 Expiry Date 18/01/29 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: 135435
120 - QC5- Inspect part completeness to step on W/O
130 - Identify as per dwg & Stock Location: TH
140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4634-3 - 164289	1	2	0	0
	D4636-5 - 164519	2	43	0	0
	AF3 - D4647-1 - 155284	1	4	0	0
	MF4 - D4664-5 - 164066	6	39	0	0
	MF3 - D4712-1 - 164607	2	4	0	0
	3 - D4732-21 - 123210-1	1	6	0	0
	3 - D4732-25 - 123212	1	7	0	0
	- D5021-3 - 154854	1	2	0	0
	ST570 - MPNY-750S-9-C - 130423-13		570	0	0
	ST312 - MS20426AD3-4 FM134394	4	5,055	0	0
	ST311 - MS20426AD4-6 - 137851	4	2,797	0	0
	AT302 - MS21059L08 - FM136554-1	2	62	0	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Middle, Center Ceiling Replacement Panel Assembly

PART NO: D4634-143

Revision:

Operation: Start up Operation

Quantity: 1

Change No:

Mfg Date: 11/02/17
Job No: 167077

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS				
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
	Approved ☐	Large Fab ☐	Composite ☐	Supplier ☐			
	QTY Effective :				MRB (QSI042) Approval		
	Disposition					Completed By	
						Lead hand / Supervisor Approval Verification	
						QC / QA Coordinator Approval	
	FAULT CATEGORY						
Wave	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
	☐ Countersink	☐ Off-set	☐ Drawing				
	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				

Past Expiry Date

Manufacturing Process

Misidentified ☐

Past Due ☐

OTHER : ☐